

Work Order ID 53477

November 6, 2009 7:22:49 AM



Page 1

Item ID: D3136-041
Revision ID: E
Item Name: Window Assembly

Accept



Setup Start



Stop



Start Date: 11/06/09 Start Qty: 6.00
Required Date: 11/06/09 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *W*
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3136	Rev E								
100	FLOW WATER JET	0.00							
	Waterjet	0.00							
	FLOW CNC Waterjet								
	Memo <i>E/E</i>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
	Quality Control								
	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
	Quality Control								
	Memo								

B 9-11-6

6

B 9-11-6

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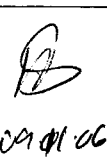
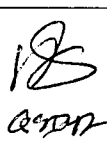
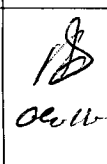
6

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-11-06	150	One window kept for engineering trial install	 C. H. R.	no replace	 09/11/06	M. 09/11/06	 09/11/06	 09/11/06

NOTE: Date & initial all entries

Work Order ID 53477

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Page 2

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Start Date: 11/06/09 Start Qty: 6.00
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Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Thermoform

THERMOFORMING MACHINE

Memo

0.00

Thermoforming Machine

1-Thermoform as per Dwg D3136 and Folio FTA0061 Dwg
Rev. E Folio Rev. C 12- Engrave Part # and
Batch # , and affix labels (D3108-9)

WL 09/11/06 (x6)

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

WL 09/11/06 (x6)

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

PTO
12B 09.11.06 x5

November 6, 2009 7:22:50 AM

Item ID: D3136-041
Revision ID: E
Item Name: Window Assembly

Accept

Setup Start

Stop

Start Date:	11/06/09	Start Qty:	6.00
Required Date:	11/06/09	Req'd Qty:	6.00

Cust Item ID:
Customer:

Reference:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Draw Number	Draw Rev.	Plan Code
----------------	--------------	--------------

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

00

[illegible]

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

170

00

00000000000000000000

QC5- Inspect part completeness to step on W/O

OC

Memo

0.00

Quality Control

180

00

Abstract

Identify as per dwg & Stock Location:

Packaging

Memo

0.00

Packaging

Work Order ID 53477

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Page 4

Item ID: D3136-041

Accept

Revision ID: E

Item Name: Window Assembly

Start Date: 11/06/09 Start Qty: 6.00

Required Date: 11/06/09 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09-11-05

MF

09-11-06

Picklist Print

November 6, 2009 7:22:48 AM

Work Order ID: 53477

Parent Item: D3136-041RevE

Parent Item Name: Window Assembly

Comments:

Start Date: 11/06/09

Required Date: 11/06/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3108-9RevB1		Manufactured	No			100	Each	804.0000	12.0000			



Decal

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	804
34554	316
46546	488

MACRLICS.125 Purchased No



1/8" Polycast II Sheet

170 sf 196.8491 26.8421



12 09/11/06.

12911-6

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT	196.8491
110115	4
110633	17.2295
111711	67.7447
112888	107.8749

12888 46.

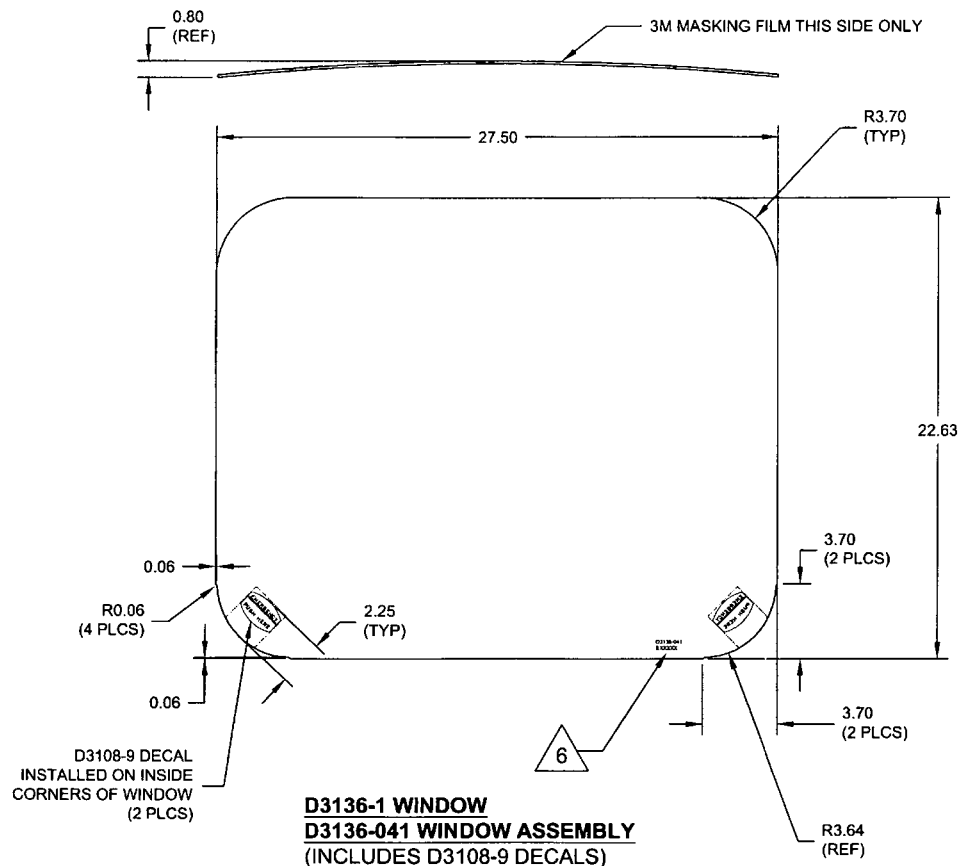
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

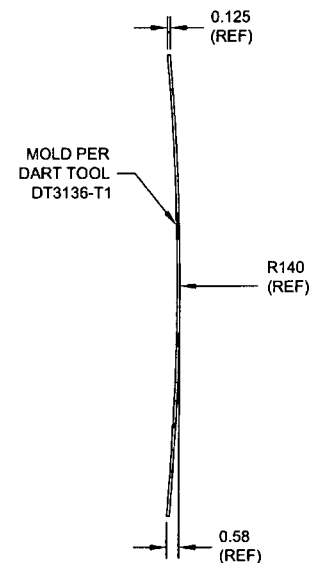
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

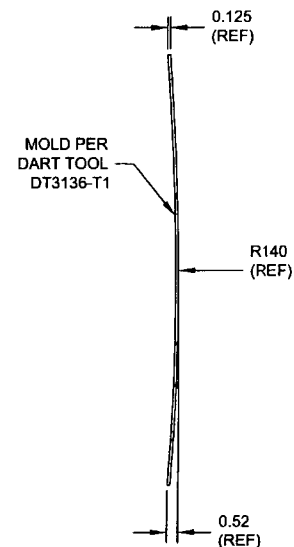
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS



RELEASED
07.09.22

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3136	REV. E SHEET 1 OF 2
TITLE WINDOW ASSEMBLY	SCALE 1:6
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D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
(INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASE
07.09.22

DESIGN	<i>4</i>	DART AEROSPACE LTD	
DRAWN	<i>JE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JE</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>JE</i>	D1316	SHEET 2 OF 2
APPROVED	<i>JE</i>	TITLE	SCALE
DE APPR.	<i>JE</i>	WINDOW ASSEMBLY	1:
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